

Date: Tuesday, 12/02/2008 2:28:55 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)
Job Number	: 37387	Part Number	: D2332041
Estimate Number	: 10258	Drawing Number	: D2332
P.O. Number	:	Project Number	: N/A
This Issue	: 12/02/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: / /	Type	: SMALL /MED FAB
Previous Run	: 36849	Material	:
Written By	:	Due Date	: 19/02/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13-11-7/5KJ/ RF		

### Additional Product

Job Number:



~~\* Scrap~~

Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total : 5.1975 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	Batch M105260 SB 08/03/07 (12)
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total : 1.3104 f(s) Material: Ø0.250" 304SS Rod	Batch M105150 SB 08/03/07 (12)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar	
		2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin	
		3-Deburr	
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.2502 f(s)/Unit Total : 15.0024 f(s) 304 RD Tube .500 x .035W	
		M 104980 (1+2)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/04/12

29

10

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

BB/03/06 12

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

12 x

A/R SS Rod Batch: M106593 M 107-051 08-04-24.

sp.

PTC

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

10.0 AN44A Bolt



SCH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4-4A	Bolt	

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod/Fab. Large NCR: Yes No DQA:  Date: 08/04/29  
 QA: N/C Closed:  Date: 08/04/29

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/24	#	During welding inspection it was found that there is a foreign object in side the Prop Arm.		ADD step to ensure there is no foreign object prior to welding	08/04/24		08/04/24	
		PC welder did not check for a foreign object prior to welding	08/04/24	SCRAP and Destroy all 12 parts. <del>**</del>	08/04/24	08/04/24	08/04/24	08/04/24

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	_____

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	_____

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

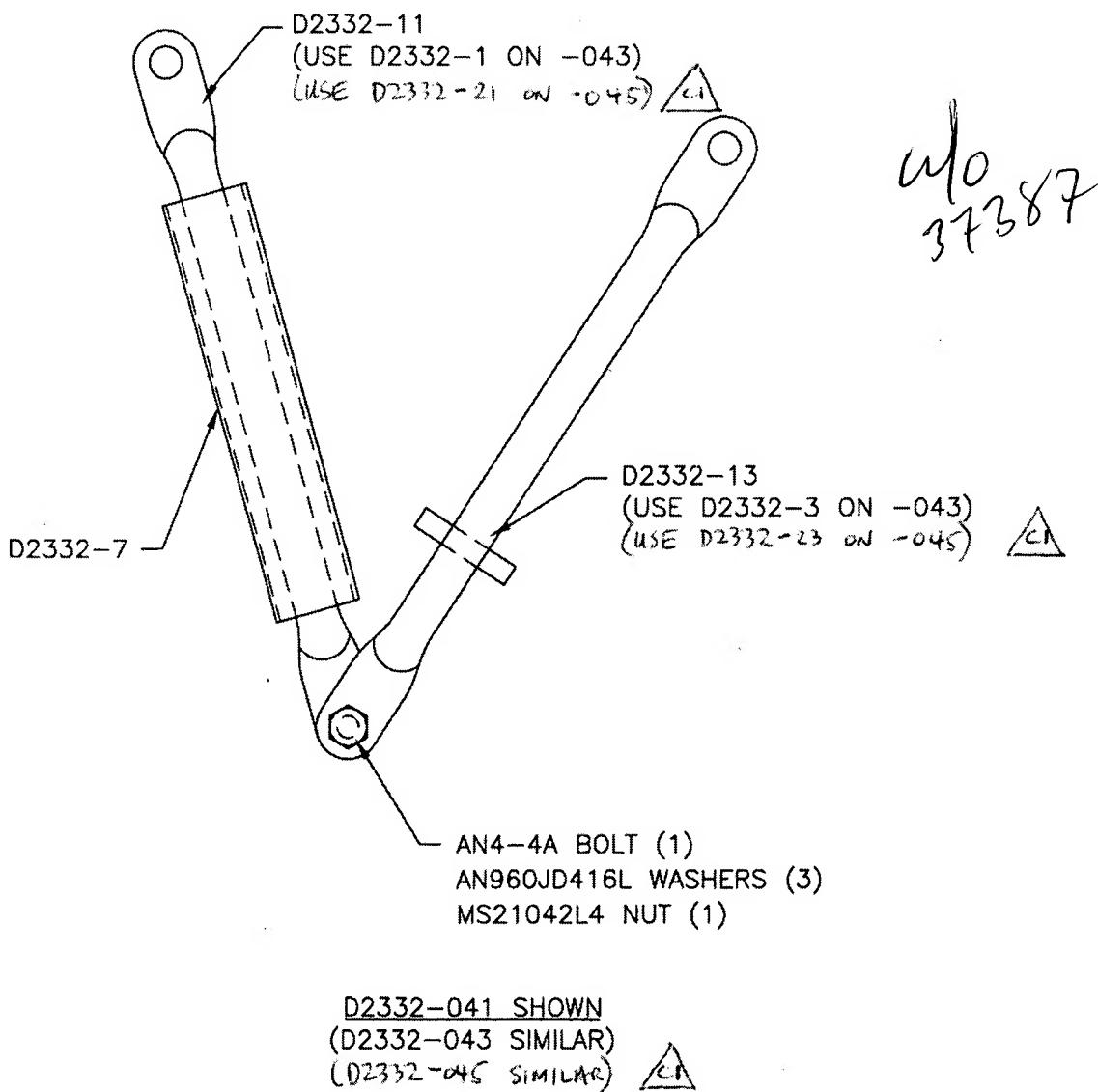
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

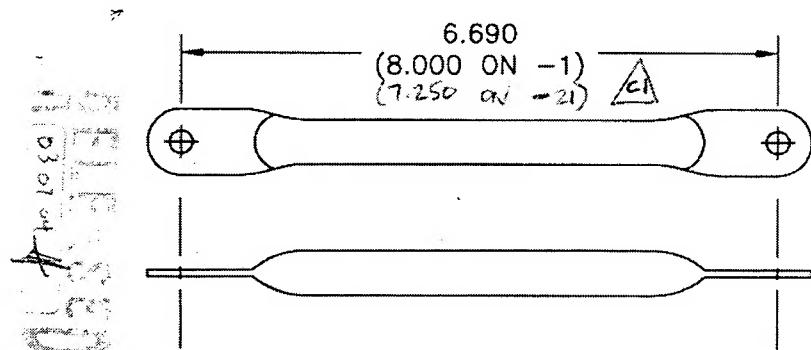
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2332 REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY SCALE NTS

A	94.12.16	NEW ISSUE
B	97.09.30	CHANGE 416 WASHERS TO 416L
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)
C1	03.08.06	ADD -045 PROP (7.25" LONG)

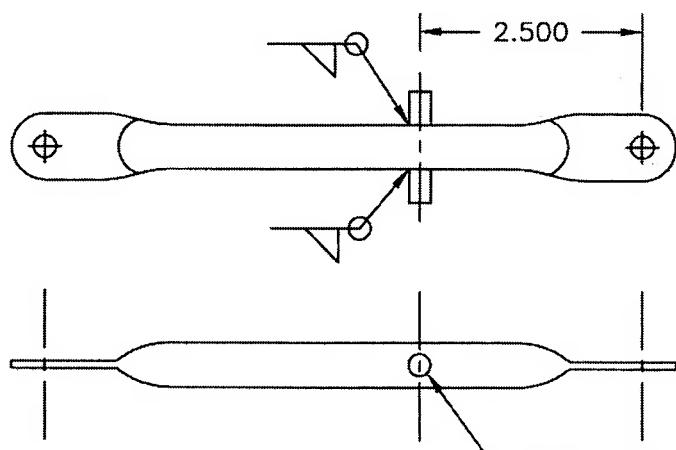


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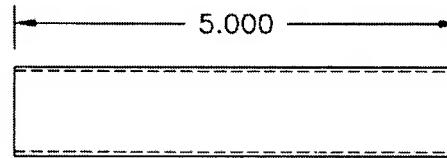
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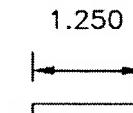
D2332-11 PROP  
(D2332-1 SIMILAR)



D2332-13  
M/F D2332-11 & D2332-5  
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

**DART**

QC COPY  
10/20/94

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	SCALE
03.07.03	LID PROP ASSEMBLY	1:2
C	MATE -041 Prop 6.69" LONG (4in) MATE -043 Prop 8.00" LONG (6in)	REV. C
C1	ADD -045 Prop (7.25" LONG)	SHEET 2 OF 2

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13